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SAs
19/11/20
D5549-011
Job Sheet 203462

POSITIVE RECALL
EFFECTIVE *12/12/20* AUTH. *SAs*
RELEASED _____ DATE _____

Part No: D5549-011
Part Name: Fwd Beam Assembly, LH

Job Qty: 1 pcs

Part Weight: 0 lbs
Job Created: 11/20/19
Due Date: 12/12/19
Type: SOLD

Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description:

Priority: Medium

Note: URF 19-880 D5549 REV.B IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/12/19		0.00	0.67	Small Fab - 1		<i>DAS</i> 58 <i>9-89</i> DEC 18 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
120	QC 5	1 pcs	12/12/19		0.00	0.00	QC 5 - 10		<i>DAS</i> 40 <i>9-89</i> DEC 1 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/12/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 4765
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	12/12/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	DEC 20 2019

Part Op 110 - 1- Install and Manufacture D2690-13 lanyard, 2- Install D5553-1 and D5554-3 with bolts and quick pin to Aft Beam.
Descriptions: Torque nut as per dwg. (see note 8) 3- Install D5550-041 to Aft Beam. Torque nut as per dwg.(see note 9)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

013473

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-26A	Bolt	8 Ea (8 ea)	110-Small Fab - 1	5183300
AN4-27A	Bolt	2 Ea (2 ea)	110-Small Fab - 1	5056285
CBL-1240	Cable	2,8000 ft (2.8 ea)	110-Small Fab - 1	5198626
CBL-460	Loop Sleeve	4 Ea (4 ea)	110-Small Fab - 1	5186085
D5549-1	Fwd Beam	1 pcs (1 ea)	110-Small Fab - 1	5119917 5184129
D5550-041	Fwd Outboard Beam Assembly	1 pcs (1 ea)	110-Small Fab - 1	5040335
D5553-1	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5119917 5237210
D5554-3	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5036043
MS17984-C625	Pin, Quick Release	2 Ea (2 ea)	110-Small Fab - 1	5158303
MS20002C6	Washer	6 Ea (6 ea)	110-Small Fab - 1	5080243
MS21042L4	Nut	10 Ea (10 ea)	110-Small Fab - 1	5228617
MS21042L6	Nut	6 Ea (6 ea)	110-Small Fab - 1	5232552
MS21250-06026	Bolt	6 Ea (6 ea)	110-Small Fab - 1	5127337
NAS1149D0463J	Washer	20 Ea (20 ea)	110-Small Fab - 1	5223595
NAS1149D0663J	Washer	6 Ea (6 ea)	110-Small Fab - 1	5220693

ST342
" "
ST447
ST76
" "
ST315
ST34
ST303
" "
52995

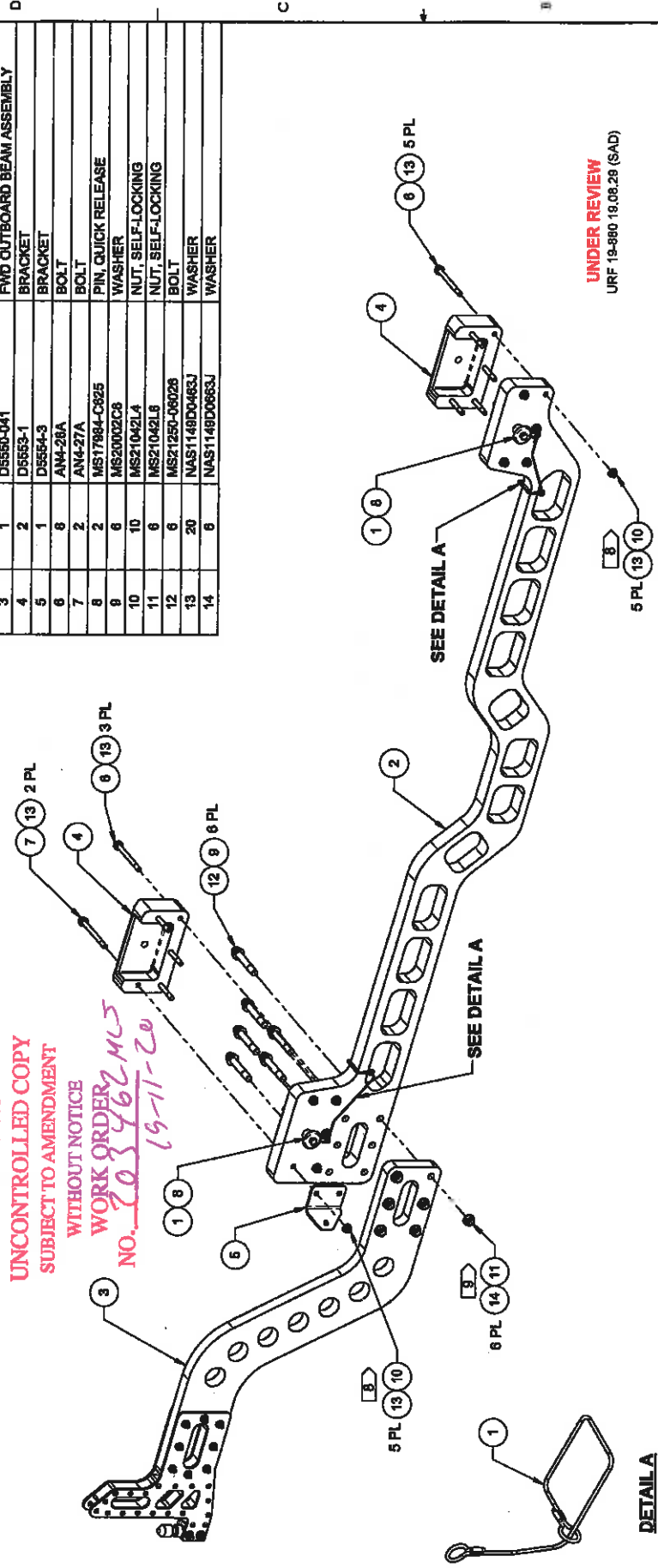
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN4-26A	8	19	0
	AN4-27A	2	26	0
	CBL-1240	3	470	0
	CBL-460	4	313	0
	D5549-1	1	1	0
	D5550-041	1	0	0
	D5553-1	2	1	0
	D5554-3	1	1	0
	MS17984-C625	2	10	0
	MS20002C6	6	20	0
	MS21042L4	10	5,285	0
	MS21042L6	6	166	0
	MS21250-06026	6	16	0
	NAS1149D0463J	20	6,830	0
	NAS1149D0663J	6	475	0
Part Specifications				
Specifications could not be found.				

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WITHOUT NOTICE
WORK ORDER
NO. 203462 ML3
19-11-20

ITEM	QTY -011	P/N	DESCRIPTION
1	2	D5549-011	FWD BEAM ASSEMBLY, LH
2	1	D2890-13	LANYARD ASSEMBLY
3	1	D5549-1	FWD BEAM
4	2	D5550-041	FWD OUTBOARD BEAM ASSEMBLY
5	1	D5553-1	BRACKET
6	8	D5554-3	BRACKET
7	2	AN4-27A	BOLT
8	2	MS17984-C3825	PIN, QUICK RELEASE
9	6	MS20000ZC8	WASHER
10	10	MS21042L4	NUT, SELF-LOCKING
11	6	MS21042L6	NUT, SELF-LOCKING
12	6	MS21250-08026	BOLT
13	20	NAS1148DQ463J	WASHER
14	6	NAS1148DQ663J	WASHER



D5549-011 FWD BEAM ASSEMBLY, LH

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 26.13 lbs
 - 8) TORQUE MS21042L6 NUT TO 50-70 IN-LBS
 - 9) TORQUE MS21042L8 NUT TO 160-180 IN-LBS

RELEASED
2019 AUG 29
SCM 14-074

APPROVED

REV.	DESCRIPTION	RF	BY	DATE
C	ADD 4 (ZN 84-9); REVISE NOTE 9 (ZN A3-5 & A3-7)	RF		18.08.01
B	QUANTITY CHANGE AN4-28A & AN4-27A (ZN D4-1, D4-2, C2-4, C4-5); PICTORIAL CHANGE ON D5549-3	RF		17.08.27
A	NEW ISSUE	RF		17.07.24
DESIGN				
DRAWN	RF			
CHECKED	RF			
MFG. APPR.	JFS			
APPROVED	VS			
DE APPR.	D5-1			
DATE	19.08.01			
DESCRIPTION				
DART AEROSPACE USA, INC.				
HILLSBORO, OR				
DRAWING NO. D5549				
REV. C				
SHEET 1 OF 9				
TITLE				
FWD/AFT BEAM ASSEMBLY				
SCALE				
NTS				
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NCR No.		Job: _____		DISPOSITION		DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Cross tube ☐		Skid-tube ☐		Eng. (Non-AW) ☐		Engineering ☐	
		Scrap ☐		Small Fab ☐		Machining ☐		Prod. Eng. Coord. ☐		Water Jet ☐	
		Use-as-is ☐		Finishing ☐		Large Fab ☐		Rec/Store/Packaging ☐		Supplier ☐	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											

Steven Drouin

From: David Shepherd
Sent: Thursday, November 28, 2019 6:49 PM
To: Steven Drouin
Subject: RE: D117 Basket

Steve,

I believe there is NO CHANGE to D5549-011 between D5549 Rev B and D5549 Rev C.
Therefore, it is OK to proceed with manufacturing D5549-011 to D5549 Rev B or D5549 Rev C.
Either drawing revision would be OK.

Regards,
David

From: Steven Drouin <sdrouin@dartaero.com>
Sent: November 28, 2019 4:11 PM
To: David Shepherd <dshepherd@dartaero.com>
Subject: D117 Basket

Hi David

Production is inquiring to make the following part D5549-011 to Rev. B for the D117-1044 basket for an order due on December 12th, but this is Under review (Ref URF19-880) the new Rev is not currently release, I think it's with FAA and we should get the approval by December 15th if I'm not mistaken.

My question would be could we make D5549-011 Rev. C for this order or should we wait for the approval from FAA and ECN to proceed.

Thank you
Steven